

Work Order ID 86214

86214

Page 1

June-22-12 3:43:44 PM

Item ID: D3147-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Pin

Stop *NS2*

Start Date: 22/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/25 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3147	Rev C
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100	DOOSAN LATHE	0.00							
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100

Doosan

Memo

0.00

Doosan Lathe

1-TURN AS PER FOLIO FA691 & DWG D3147
FOLIO REV: N/A
DWG REV: C
2-DEBURR AS REQUIRED

DAS
13
2-89

12/7/27

13

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
-----	---	------	--	--	--	--	--	--	--

110

QC

Memo

0.00

Quality Control

DAS
13
2-89

12/7/27

13

120	QC8- Inspect parts - second check	0.00							
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120

QC

Memo

0.00

Quality Control

DAS
14
2-89

12/07/27

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pin

Start Date: 22/06/2012 Start Qty: 12.00 ***12***

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 12.00 ***12***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>30</u>	0.00							
130						13		12/7/31	
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/7/31

MCJ 12/07/130

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 86214

86214

Parent Item: D3147-1

D3147-1

Parent Item Name: Pin

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev A New Issue 07-01-26 JLM
 IPP Rev:B Now on Cnc 07-05-02 JLM
 IPP Rev:C Now on Doosan 08-10-14 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.187		Purchased	No			100	f	14.8300	0.225	2.842105			

M303R0 187

303 Round Bar 0.187"

**

DAS
13
9-89

12/7/27

Location

MAT028

114968

120349

Loc Qty

14.83

7.83

7

Loc Code

2.1 Lt

W/O:		WORK ORDER CHANGES					
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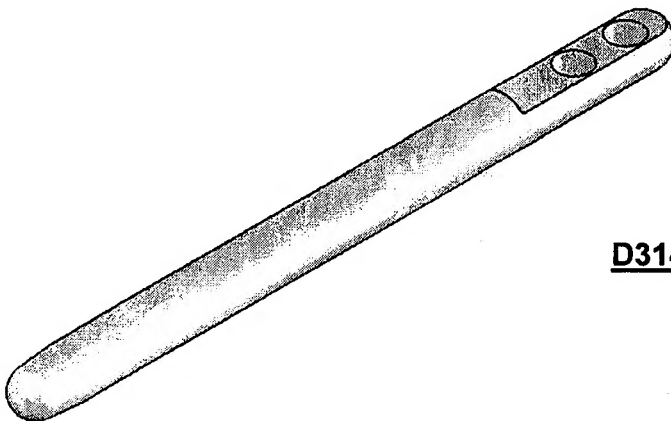
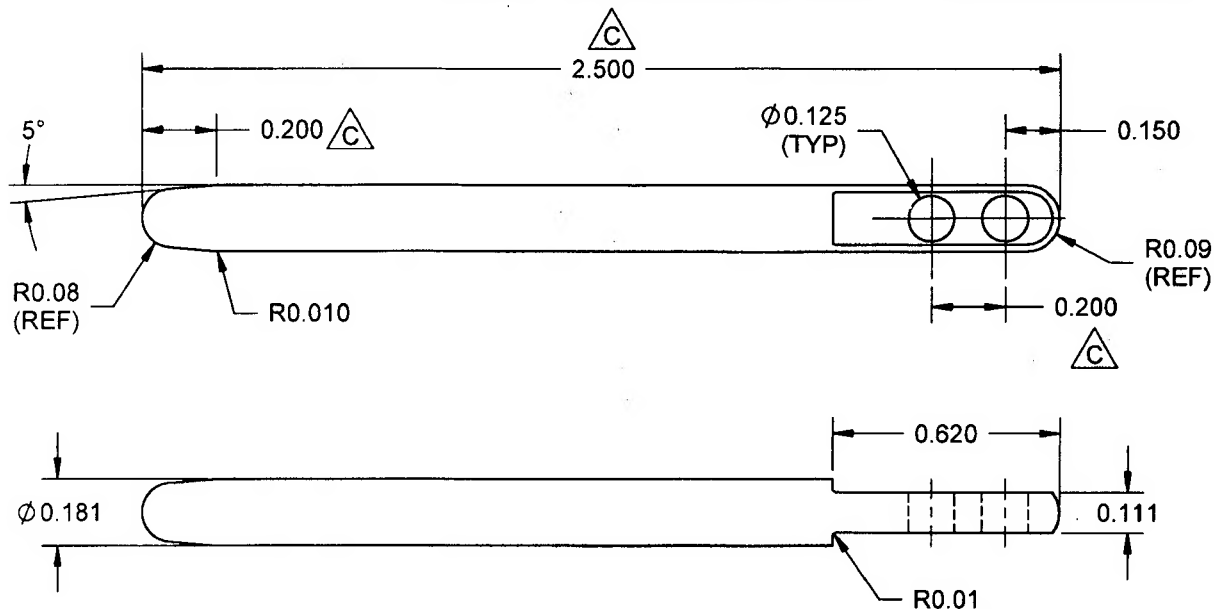
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

DESIGN #	DRAWN BY JH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED JH	DRAWING NO. D3147	REV. C SHEET 1 OF 1
DATE 06.12.04	TITLE PIN SCALE 2:1		
REV	DATE	DESCRIPTION	
A	02.04.23	NEW ISSUE	
B	04.10.18	ADD PART MARKING AND NORMALIZED	
C	06.12.04	ADD SECOND Ø0.125 HOLE; CHANGE MATERIAL; 0.200 TAPER WAS 0.400; REMOVE SUPPLIER AND FINISHING	

**D3147-1 PIN**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86214 MLS
12/06/25
RELEASED
07-01-22

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR (REF DART SPEC M303R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3147-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015 MAX
- 7) REPLACES PREMIER P/N B30-23000-119

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